

*Bitel*  
**Work Order ID 54981**

January 5, 2010 11:28:28 AM



Page 1

Item ID: D2435

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 206

Start Date: 05/01/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/01/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RL*

Date: *10-1-05* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILED2435

*FB 10-1-14*

*(4)*

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435  
3-Deburr

*S.F. 10/01/20*

*4 0*

140

0.00



QC2- Inspect parts off machine FA1/FA1B

QC

Memo

0.00

Quality Control

*S.F. 10/01/20*

*4 0*

| W/O:. |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|-------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE  | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|       |      |                    |    |      |     |                                     |                          |
|       |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 54981**

January 5, 2010 11:28:28 AM



Page 2

Item ID: D2435

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 206

Start Date: 05/01/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

DTP 10/01/20

4

Quality Control

151

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

10-1-20 YD 90

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/20 JF

MF 10-1-20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 11:28:32 AM

Page 1

Work Order ID: 54981

Parent Item: D2435

Parent Item Name: Bearpaw, 206

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/<br>Item Name | Placement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|----------------------|---------------|-------------|---------------------|------------------|--------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|----------------------|---------------|-------------|---------------------|------------------|--------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

MUHMWB10

Purchased

No

120

sf

275.3641

12.8000



13 10-1-14

UHMW 1" Black

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

243.6164

112186

122.0164

113166

121.6

Main Warehouse

ST

31.7477

111354

31.7477

4

113166

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|   |  |                     |       |
|---|--|---------------------|-------|
| <b>DART AEROSPACE LTD</b>                   |  | <b>Work Order:</b>  | 54981 |
| <b>Description:</b> Bearpaw                 |  | <b>Part Number:</b> | D2435 |
| <b>Inspection Dwg:</b> D2435 <b>Rev:</b> E1 |  | <b>Page 1 of 1</b>  |       |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

| Inspection Sheet<br>Drawing Dimension |             | Tolerance     | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|-------------|---------------|---------------------|--------|--------|-------------------------|----------|
| A                                     | 0.063 x 45° | +0.030/-0.010 | .063                | ✓      |        |                         |          |
| B                                     | 5.500       | +/-0.030      | 5.508               | ✓      |        |                         |          |
| C                                     | 0.200       | +/-0.030      | .200                | ✓      |        |                         |          |
| D                                     | R0.250      | +/-0.030      | .250                | ✓      |        |                         |          |
| E                                     | 0.250       | +/-0.010      | .256                | ✓      |        |                         |          |
| F                                     | 0.625       | +/-0.030      | .630                | ✓      |        |                         |          |
| G                                     | 0.25 x 45°  | +/-0.030      | .25                 | ✓      |        |                         |          |
| H                                     | 0.375       | +/-0.010      | .382                | ✓      |        |                         |          |
| I                                     | 19.000      | +/-0.030      | 19.00               | ✓      |        |                         |          |
| J                                     | 0.950       | +0.030/-0.010 | .958                | ✓      |        |                         |          |
| K                                     | Ø0.260      | +0.005/-0.000 | .260                | ✓      |        |                         |          |
| L                                     | Ø0.930      | +/-0.030      | .922                | ✓      |        |                         |          |
| M                                     | 0.30        | +0.030/-0.000 | .304                | ✓      |        |                         |          |
| N                                     | 0.375       | +/-0.030      | .385                | ✓      |        |                         |          |
| O                                     | 7.375       | +/-0.030      | 7.375               | ✓      |        |                         |          |
| P                                     | 4.250       | +/-0.010      | 4.250               | ✓      |        |                         |          |
| Q                                     | 2.000       | +/-0.030      | 2.016               | ✓      |        |                         |          |
| R                                     | 9.000       | +/-0.010      | 9.000               | ✓      |        |                         |          |
| S                                     | 15.750      | +/-0.030      | 15.750              | ✓      |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |

|                               |                              |                            |     |
|-------------------------------|------------------------------|----------------------------|-----|
| <b>Measured by:</b> <i>JS</i> | <b>Audited by:</b> <i>DT</i> | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 10/01/20         | <b>Date:</b> 10/01/20        | <b>Date:</b>               |     |

| Rev | Date     | Change                    | Revised by     | Approved |
|-----|----------|---------------------------|----------------|----------|
| A   | 03.09.22 | New Issue      P/O K10007 | KJ/RF <i>+</i> | <i>+</i> |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



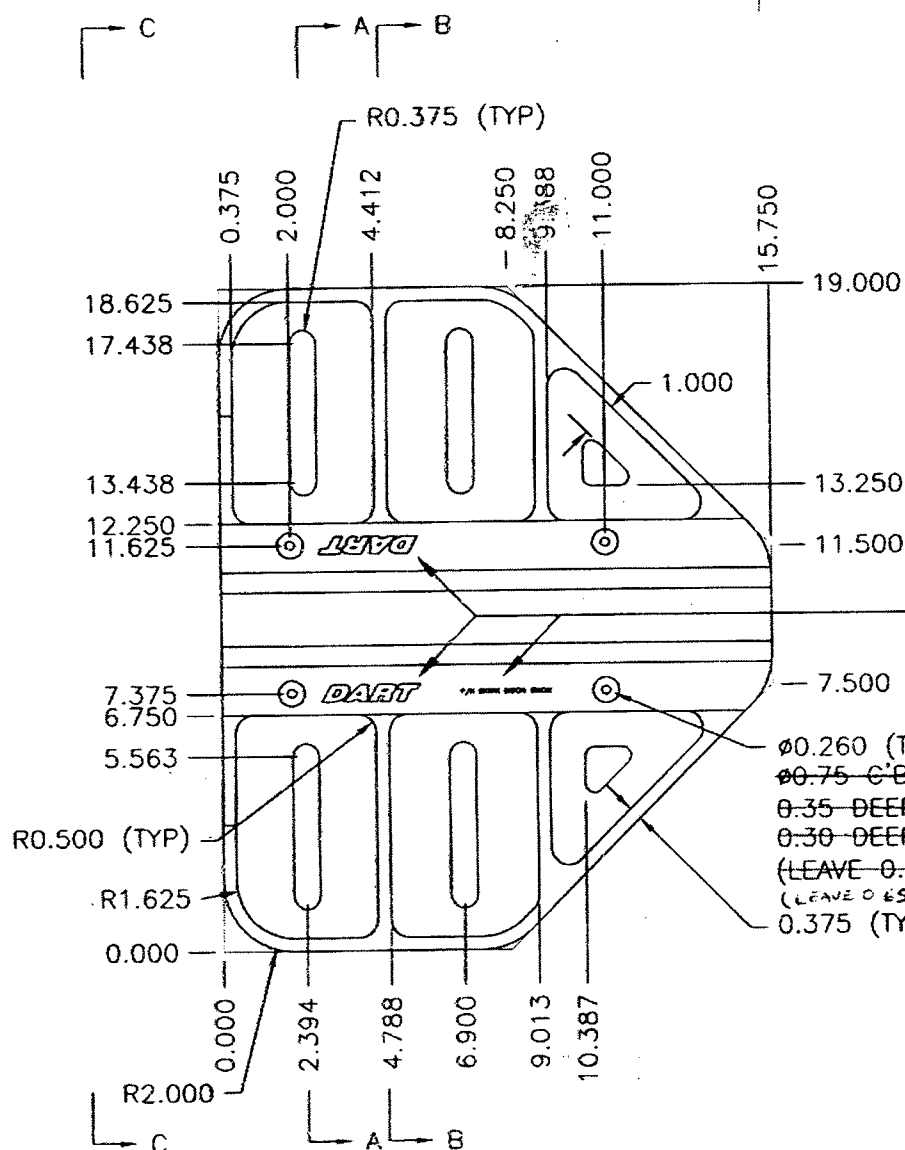
AT 10-1-05





|          |            |                                 |              |        |
|----------|------------|---------------------------------|--------------|--------|
| DESIGN   | DRAWING BY | DRAWING NO.                     | SHEET 1 OF 2 | REV. # |
| CHECKED  | APPROVED   |                                 |              |        |
| DATE     |            | TITLE                           | SCALE        |        |
| 98.05.19 |            | BEARPAW                         | 1:5          |        |
| A        | 96.01.24   | NEW ISSUE                       |              |        |
| B        | 96.03.26   | CHANGE BORE AND C'BORE DEPTH    |              |        |
| C        | 97.05.07   | CHANNEL & C'BORE DEPTH CHANGED  |              |        |
| D        | 97.10.17   | R1.5 BORE WAS R2.637 (TSR A469) |              |        |
| E        | 98.05.19   | CHANGE C'BORE, R1.58 WAS R1.50  |              |        |

430617 KGE

ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)



~~Ø 0.260 (TYP) Ø 0.93 C" BORE~~  
~~Ø 0.75 C" BORE 0.30 DEEP FROM BOTTOM~~  
~~0.35 DEEP FROM TOP (MIN.)~~  
~~0.30 DEEP FROM BOTTOM~~  
~~(LEAVE 0.300 MIN.)~~   
~~(LEAVE 0.650 MIN.)~~  
~~0.375 (TYP)~~ 

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

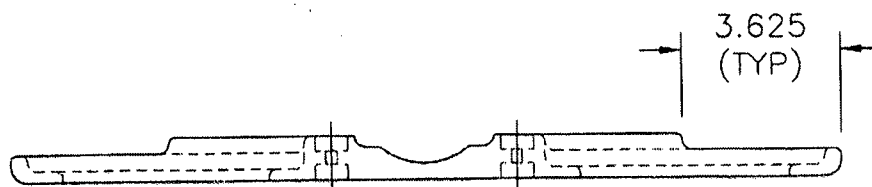
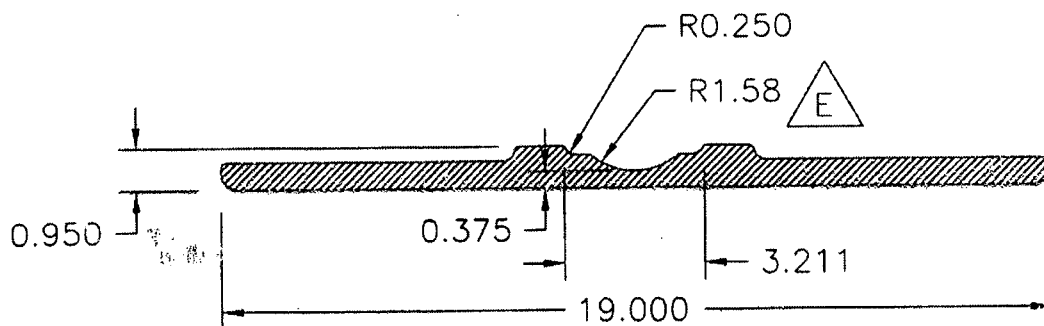
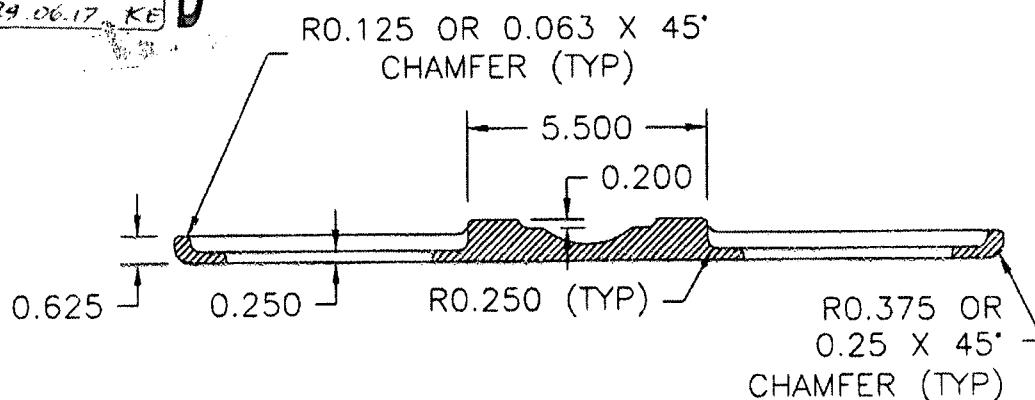
**NOTE:** Date & initial all entries



W/O 54981

|                  |                         |   |                        |
|------------------|-------------------------|---|------------------------|
| DESIGN<br>KE     | DRAWN BY<br>KE          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>DJP   | APPROVED<br>[Signature] | DRAWING NO.<br>D2435                              | REV. E<br>SHEET 2 OF 2 |
| DATE<br>98.05.19 |                         | TITLE<br>BEARPAW                                  | SCALE<br>1:4           |

RELEASED  
99.06.17 KE



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries